

Work Order ID 68642

Page 1

Tuesday, April 19, 2011 12:54:27 PM

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mk Date: 11-04-19

Tooling:

Date:

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

0.00



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Replacement Float Skidtube

Start Date: 4/19/2011 Start Qty: 1.00



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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



HandFinish

HandFinishing

Hand Finishing

Memo

0.00

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/R ☐ Sikaflex-241/-291 ☐ N1116912
Expiry date: ☐ 12/01

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 ☐ N1116912
Expiry date: ☐ 12/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
A/R ☐ LPS Procyon ☐ N1114596

1 ϕ N1116912

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Page 3

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Setup Start

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Start Date: 4/19/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00

Customer:





Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00					0	01	29 ①
130  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____	0.00 0.00		PPP 66301			11/4/29 SP		
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/4/29 JF CMF 11-04-29

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Picklist Print

Tuesday, April 19, 2011 12:54:23 PM

Page 1

Work Order ID: 68642

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube



Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
IPP Rev:C 07-05-28 As per Rev F JLM
IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			110	Each	2,358.000	24	24		11/04/29	
				<u>Location</u>				<u>Loc Qty</u>					
				ST350				2358					
				116924				358				124	
				117094				1000					
				117313				1000					
AN3C6A  BOLT		Purchased	No			110	Each	224.0000	12	12		11/04/29	
				<u>Location</u>				<u>Loc Qty</u>					
				FP-A				1					
				111982				1					
				ST351				223					
				111982				2					
				116419				71					
				116549				50				x12	
				116704				100					

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Parent Item Name: Replacement Float Skidtube

Start Date: 4/19/2011


Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No
BOLT

110 Each 171.0000 8 8


 all 11/04/29

Location	Loc Qty	Loc Code
ST351	171	
113149	30	<u>x8</u>
116169	41	
117313	100	

AN960C10L NAS1149C0332 Purchased No
R

110 Each 0.0000 44 44



washer

M117291  (x44) all 11/04/29

D3391-021 Manufactured No

110 Each 0.0000 1 1



B41838  (x1) all 11/04/29

Fwd Tube Assembly

D3391-023 Manufactured No

110 Each 0.0000 1 1




B68679  (x1) all 11/04/29

Mid Tube Assembly

D3391-025 Manufactured No

110 Each 1.0000 1 1



B66007  (x1) all 11/04/29

Aft Tube Assembly

Location	Loc Qty	Loc Code
FP	1	
48122	1	

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Parent Item Name: Replacement Float Skidtube

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-1

Manufactured No

110

Each

17.0000

1

1



Wearshoe



all 4/10/24

LocationLoc QtyLoc Code

FG

2

33798

2

FP019

15

58823

1

64747

14

X1

D3564-3

Manufactured No

110

Each

14.0000

1

1



Wearshoe



all 4/10/24

LocationLoc QtyLoc Code

FG

2

33764

2

FP019

12

62835

3

64748

5

66000

4

X1

D3564-5

Manufactured No

110

Each

24.0000

1

1



Wearshoe



all 4/10/24

LocationLoc QtyLoc Code

FG

2

34806

2

FP019

22

66551

10

67588

12

X1

Tuesday, April 19, 2011 12:54:24 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
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Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-1

Manufactured No

110

Each

36.0000

2

2



Gasket



all 4/19/11

Location

Loc Qty

Loc Code

FP015

36

68344

36

x2

D3566-5

Manufactured No

110

Each

27.0000

1

1



Gasket



all 4/19/11

Location

Loc Qty

Loc Code

FP015

27

66552

5

67589

22

x1

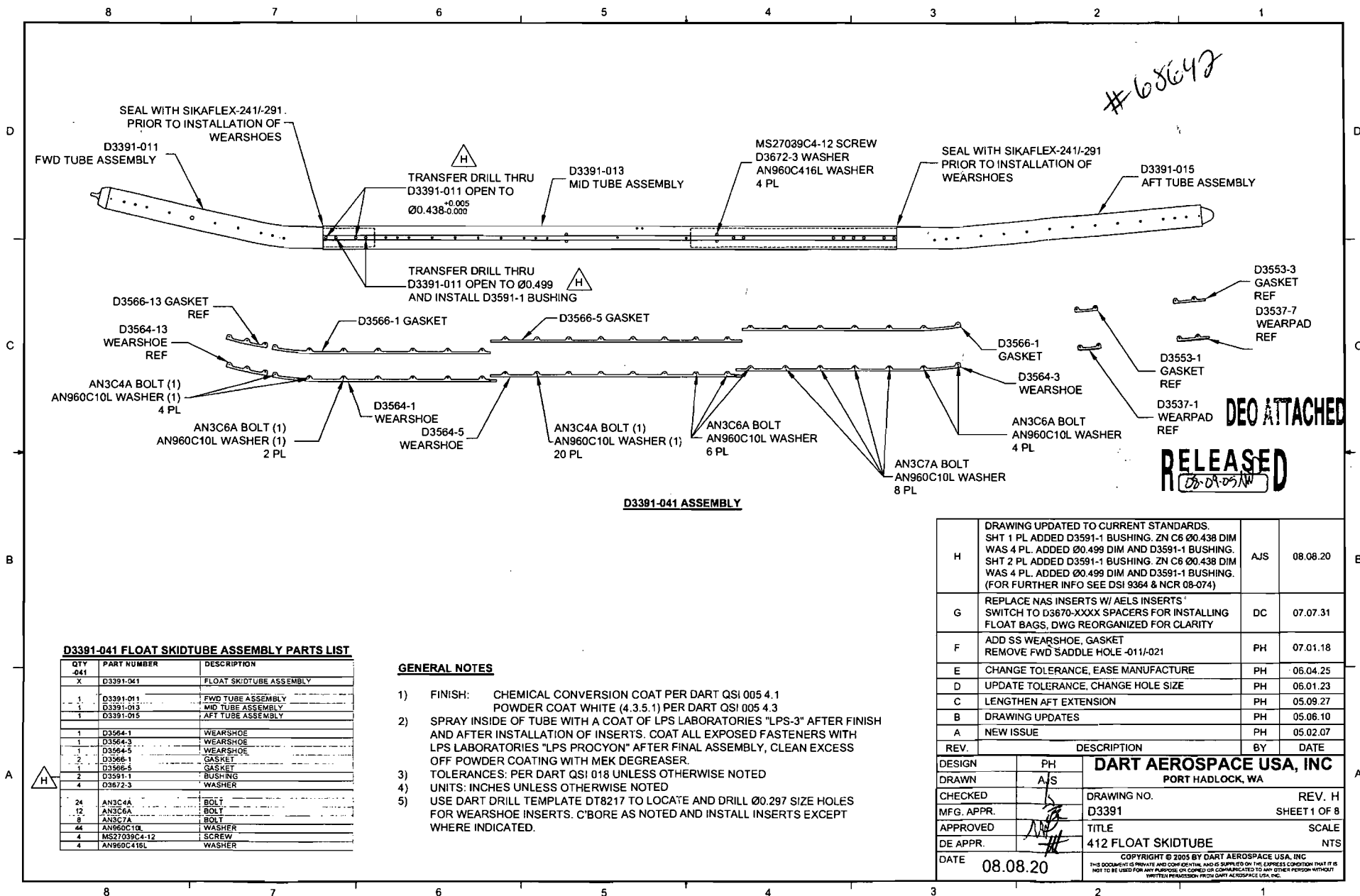
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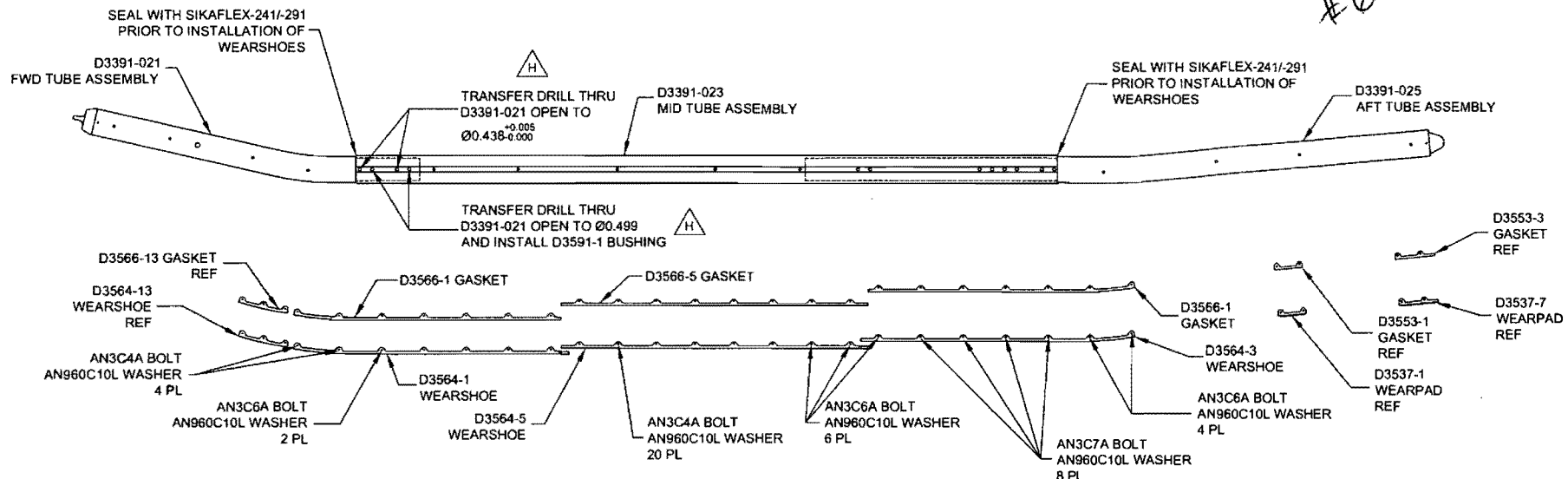
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#658642



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3566-1	GASKET
1	D3566-3	GASKET
1	D3566-5	GASKET
1	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED
RELEASED
08-09-05

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

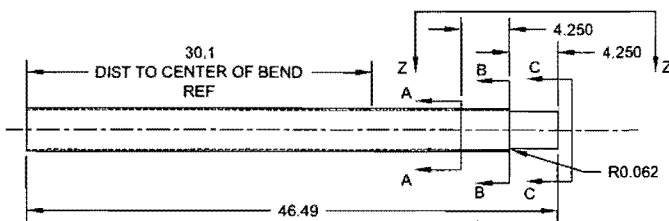
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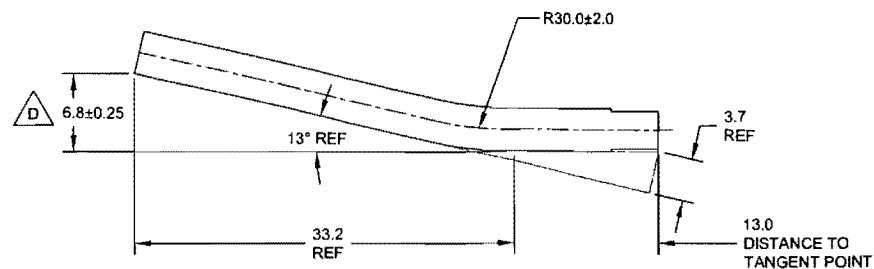
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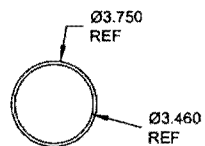
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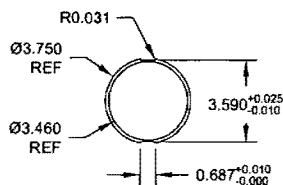
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



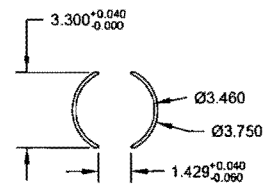
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



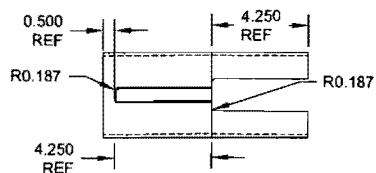
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

#-68642

DEO ATTACHED
RELEASED
8-3-05 W

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.		SHEET 3 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

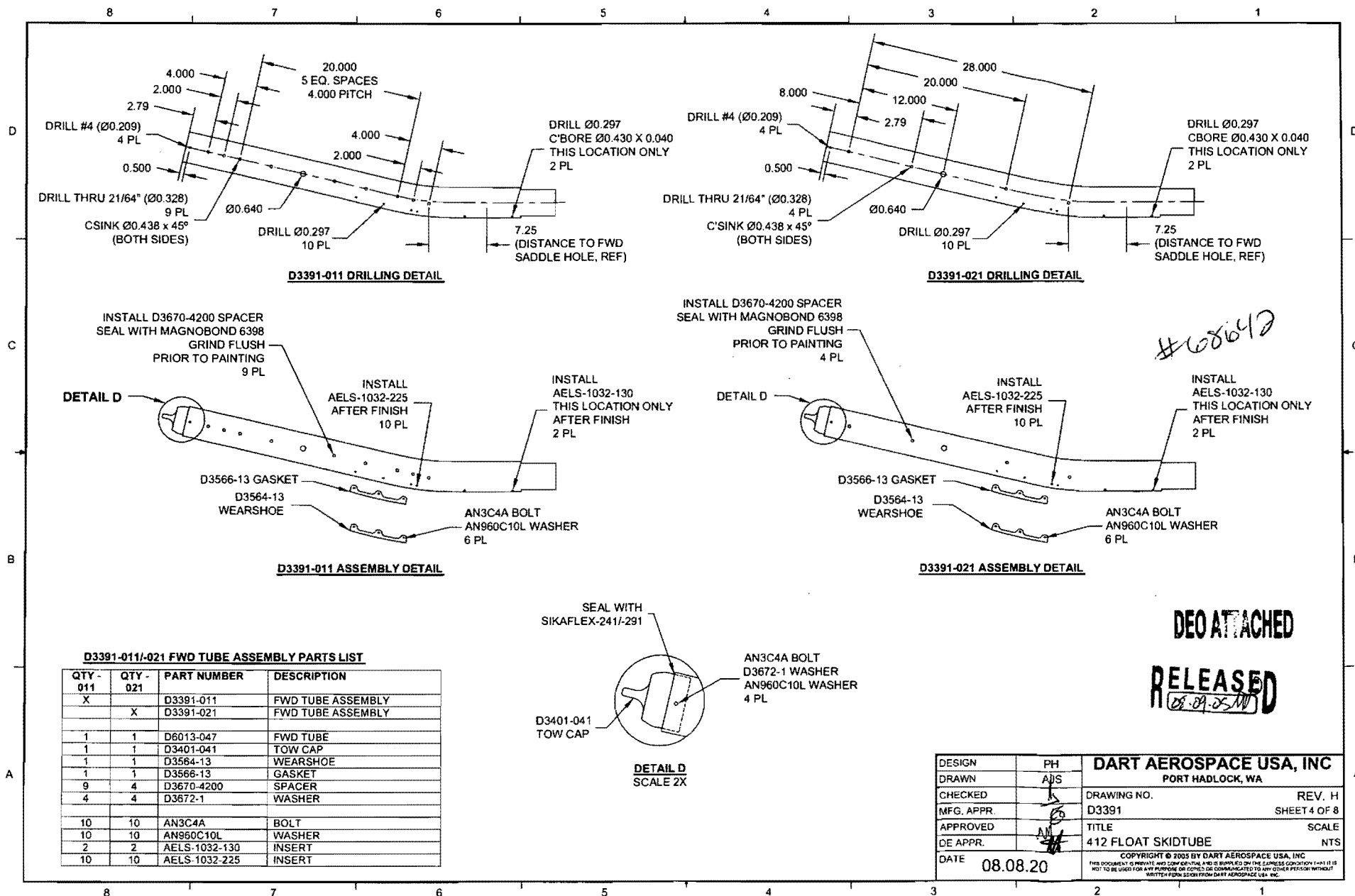
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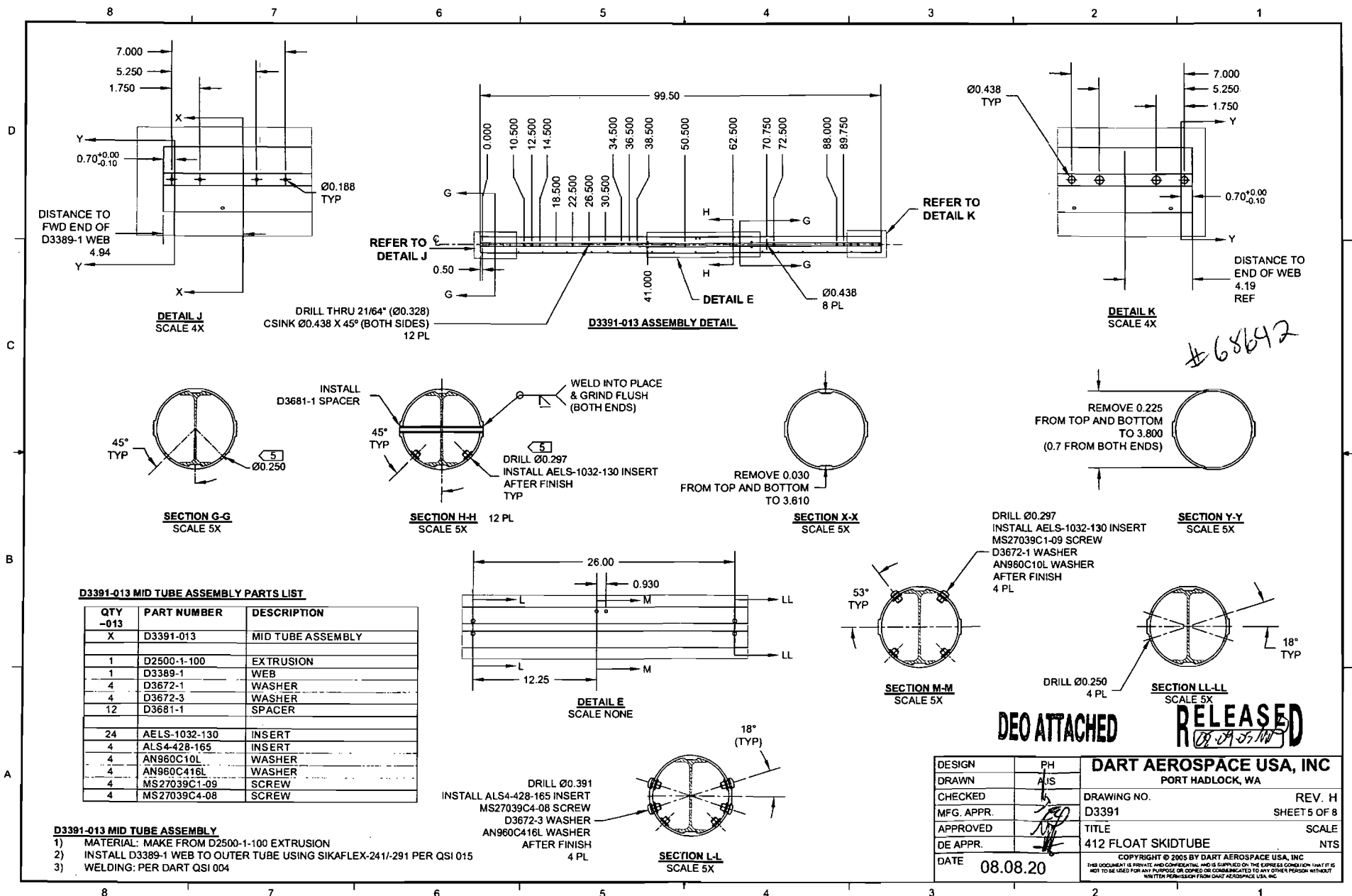
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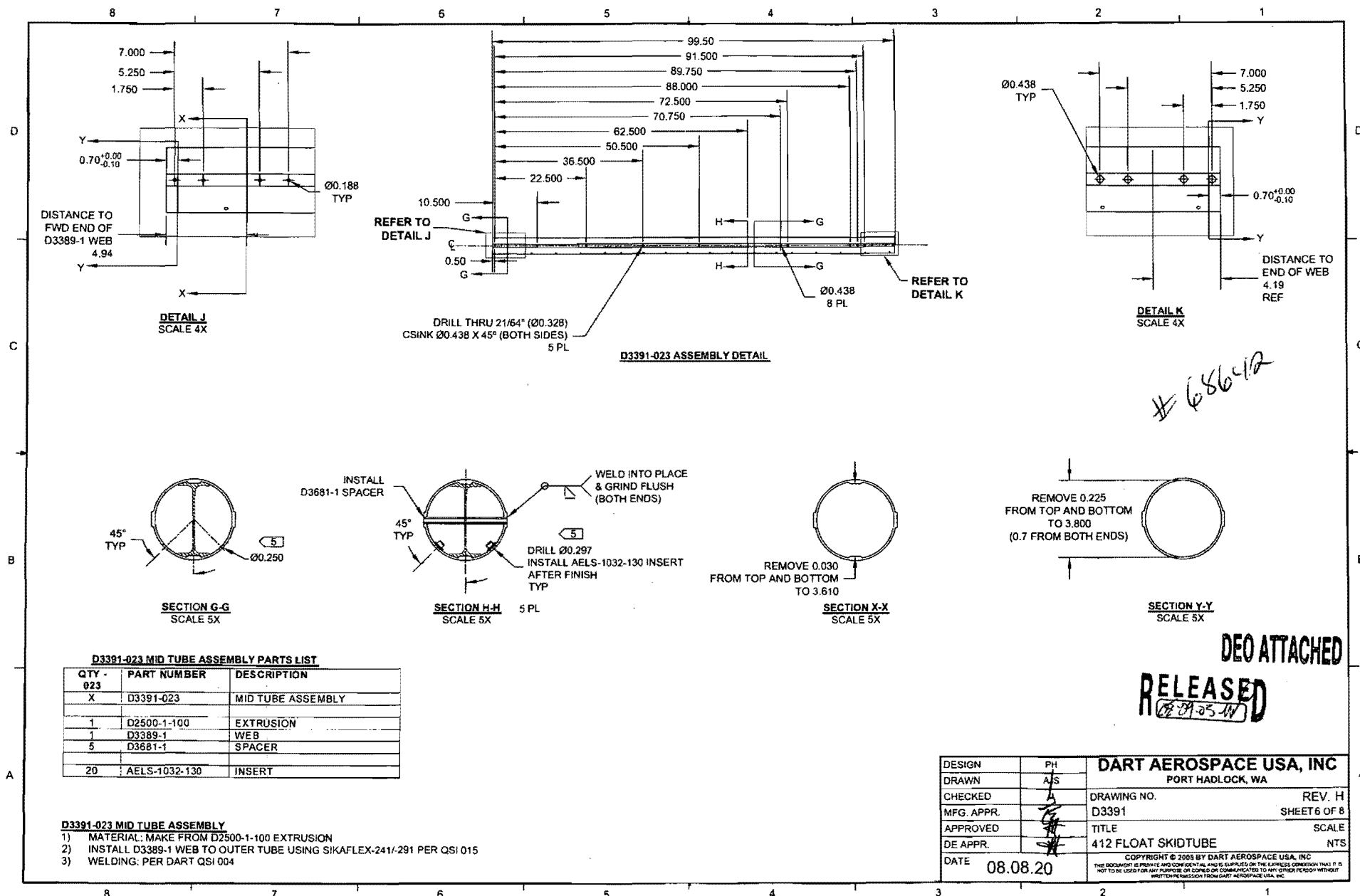
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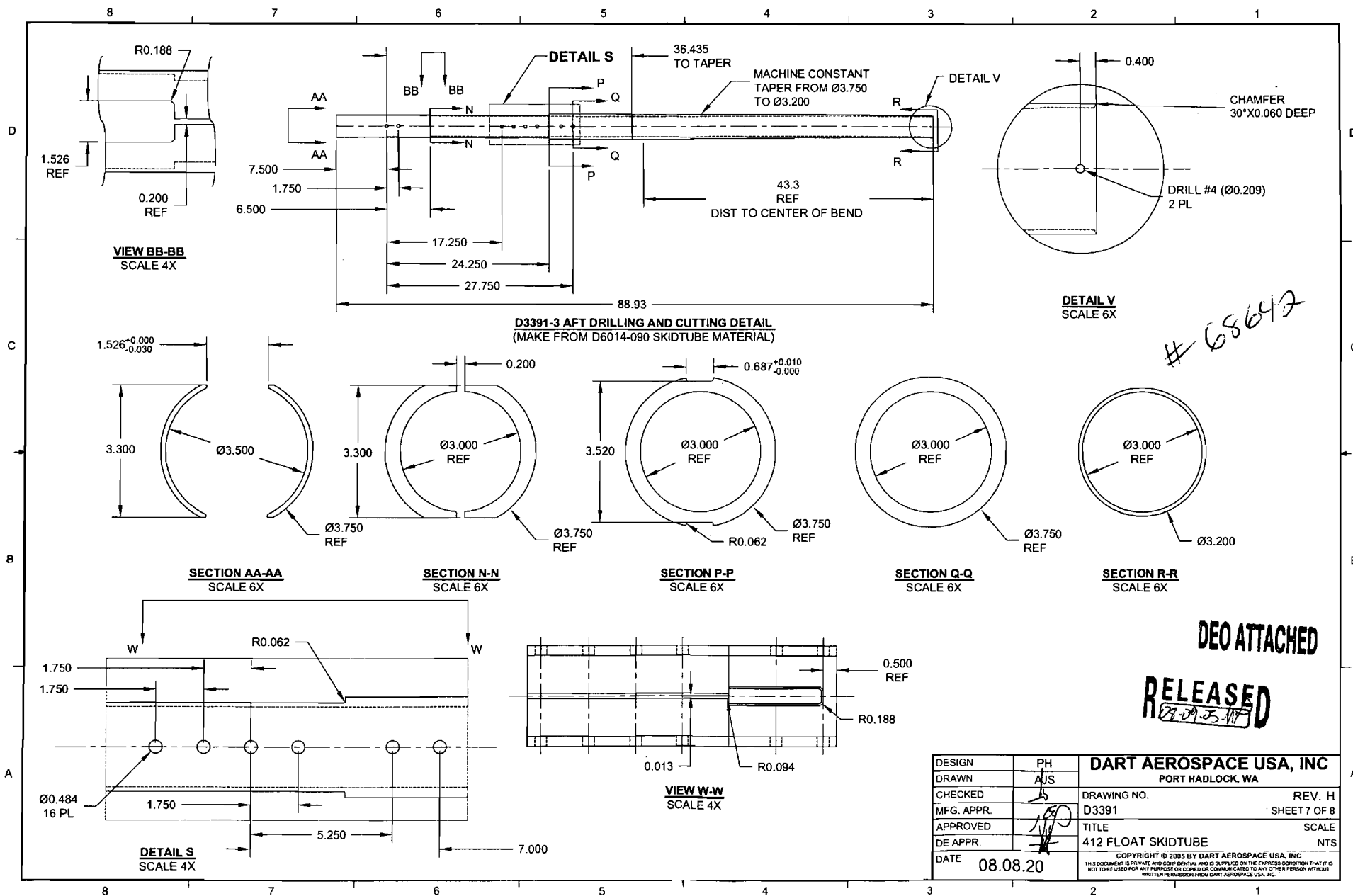
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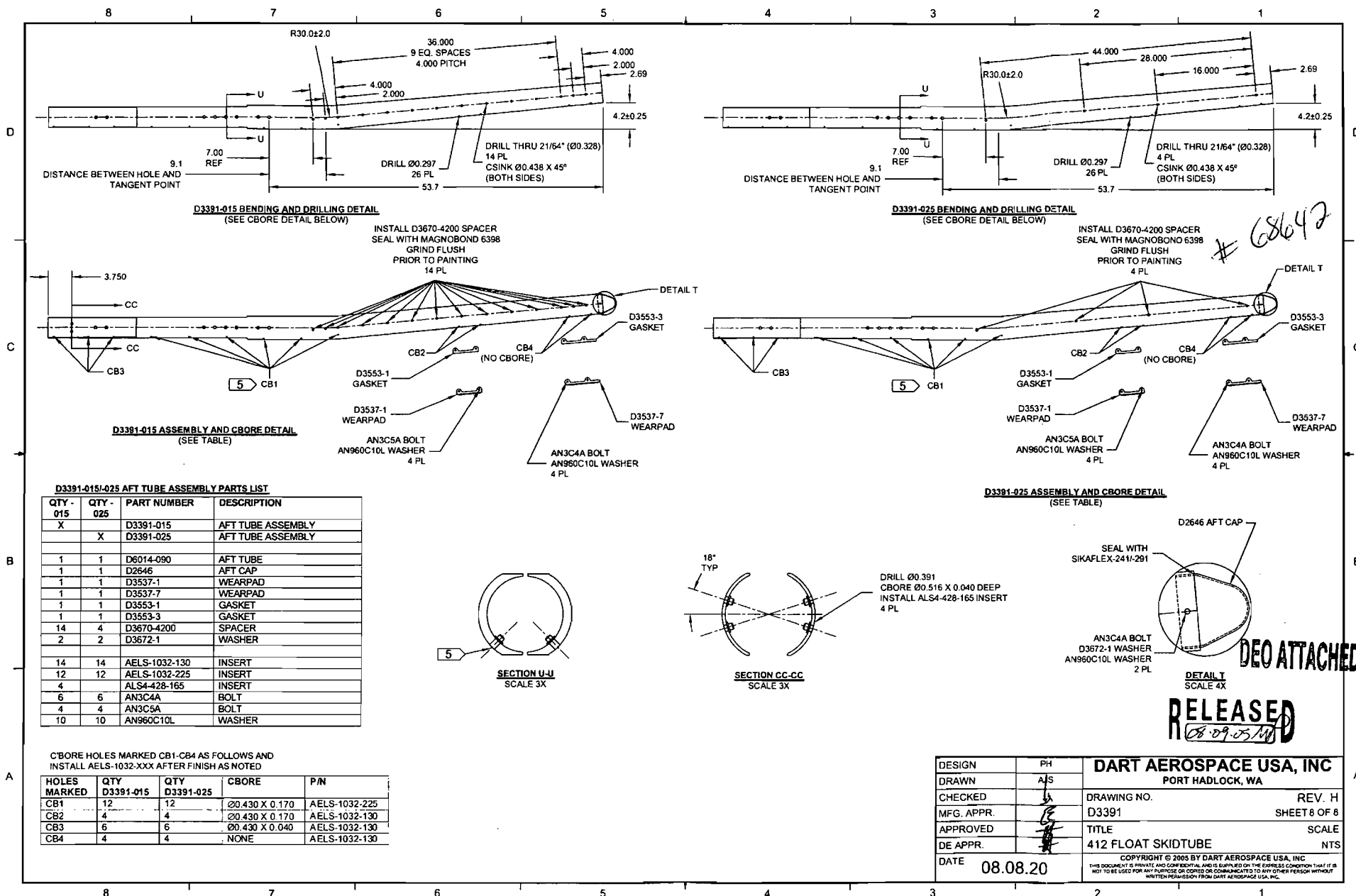
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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS 3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02

MP

68642

W/O:		WORK ORDER CHANGES					
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